

Work Order ID 69715

Tuesday, May 17, 2011 3:31:08 PM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Item Name: Float Web (206L/407)

Stop



Start Date: 5/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *JMK*

Date: 11-05-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3282	Rev C								
100	Skidtubes	0.00							
	Skidtubes								
	Memo	0.00							
	1-Cut to length as per Dwg D3282.								
	2-inspect for surface damage as per QSI0018								
	3-Deburr								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1									
HAAS CNC vertical machine #1	Memo	0.00							
	1-Machine as per Folio FA579 & Dwg D3282								
	2-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

DP
11-5-17
6
B.A 11/08/03
6 φ
B.A 11/08/03
6 φ
0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

ark/11/08/08

6 0

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

TW 11-08-08

Hand Finishing

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

DP

11-8-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Start Date: 5/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Skidtubes

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Skidtubes

0.00

Memo
1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 2011656

SAO 11-08-09

170



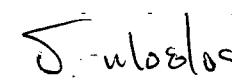
QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo



180



Packaging

Packaging

Identify as per dwg & Stock Location: LG

0.00

Memo

0.00



B1/08/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Float Web (206L/407)

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Start Date: 5/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**

Tool ID

Tool

**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/08/09

NF
11-08-09

Picklist Print

Page 1

Tuesday, May 17, 2011 3:31:03 PM

Work Order ID: 69715



Parent Item: D3282-041



Parent Item Name: Float Web (206L/407)

Start Date: 5/17/2011

Required Date: 5/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:B□05.09.23□Procedure change□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130		Manufactured	No			160	Each	30.0000	1	6			

EXTRUSION

D2792-130		Manufactured	No	Location		Loc Qty	Loc Code	1	6			11-5-17	
				HALL	61630								
D2792-130		Manufactured	No			160	Each	30.0000	1	6			

EXTRUSION

D3283-1		Manufactured	No	Location		Loc Qty	Loc Code	2	12			11-08-09	
				HALL	61630								
D3283-1		Manufactured	No			160	Each	55.0000	2	12			

Doubler

MS20470AD4-7		Purchased	No	Location		Loc Qty	Loc Code	57	342			11-08-09	
				ST045	66947								
MS20470AD4-7		Purchased	No			100	Each	1,872.000	57	342			

Rivet, Universal Head

MS20470AD4-7		Purchased	No	Location		Loc Qty	Loc Code	57	342			11-08-09	
				ST320	116081								
MS20470AD4-7		Purchased	No			1872							

Rivet, Universal Head

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	6915
Description: Float Web	Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

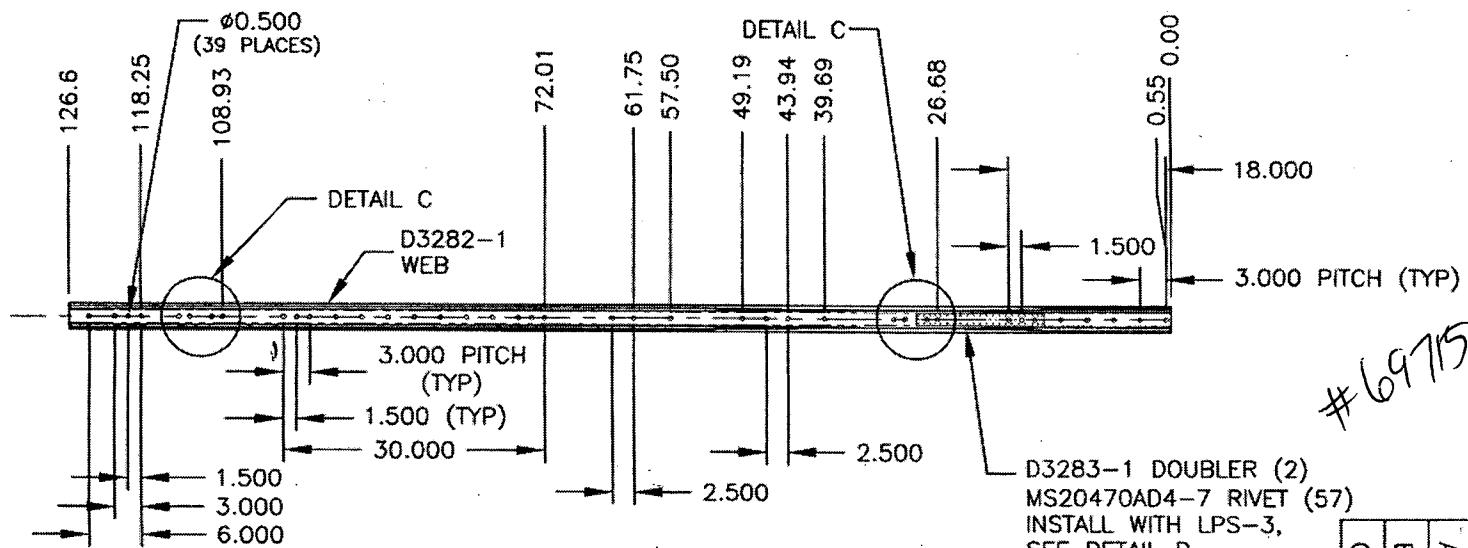
Measured by:	B.A	Audited by:	<i>anf</i>	Prototype Approval:	N/A
Date:	11/08/03	Date:	11/08/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	[Signature]

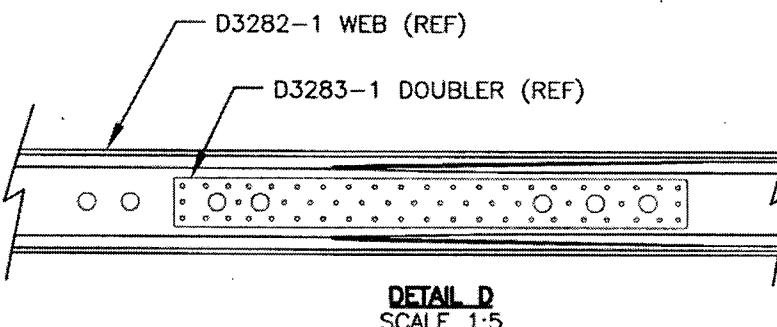
DART

DESIGN CP DRAWN BY CP DART AEROSPACE USA, INC.
PORT HADLOCK, WA
REV. C

CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
A		D3282	
DATE		TITLE	SCALE
05.08.09		FLOAT WEB, 206L/407	1:20
B		MOVE HOLES, ADD D3390-1 DOUBLERS	
C	05.08.09	REMOVE D3390-1, NOW MACHINED	



#6975



DETAIL D
SCALE 1:5

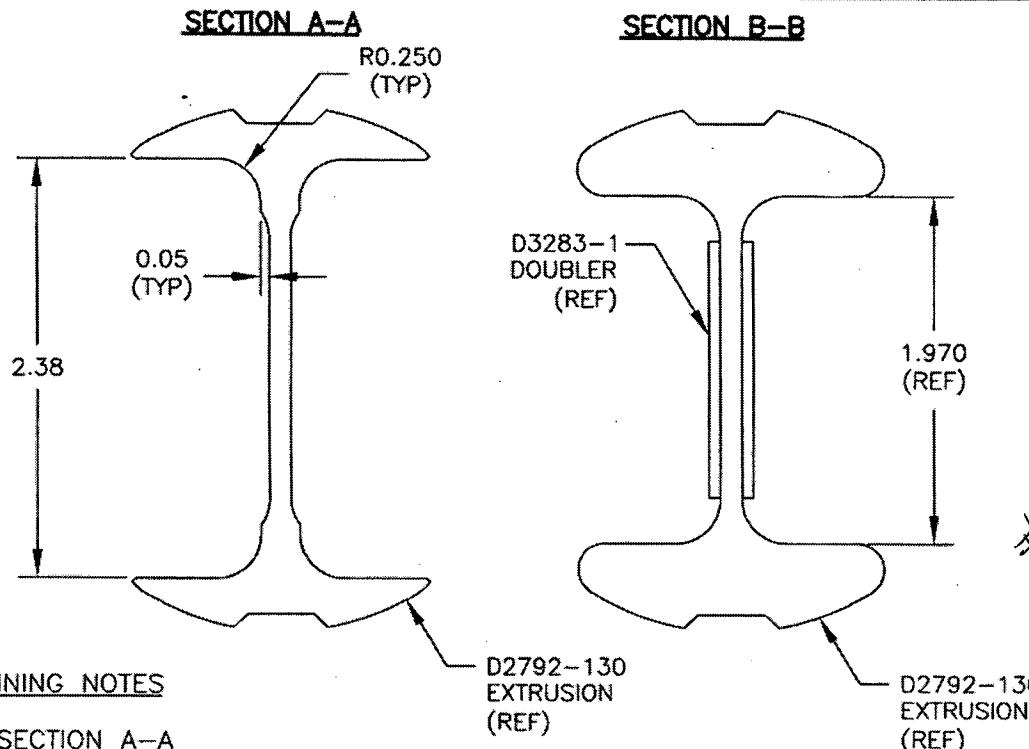
RELEASED
05.09.12

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

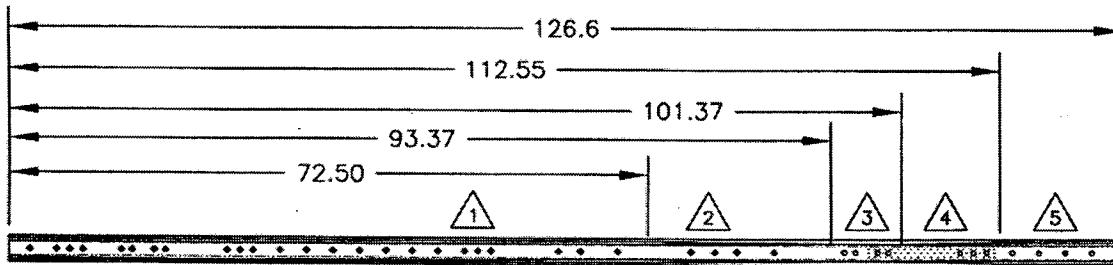
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D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 ($\varnothing 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05-01-12

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	REV. C
		DRAWING NO.
		D3282
DATE	TITLE	SHEET 2 OF 2
05.08.09	FLOAT WEB, 206L/407	SCALE
		1:20